



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2521**Job Sheet 196290****Part No:** D2521**Job Qty:** 6 pcs**Part Name:** Individual Bearpaw**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/11/19**Job Tracking No:****Due Date:** 7/12/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV LIPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	6 pcs	7/12/19	7/12/19	0.17	2.26	Waterjet - Omax		2019/07/10 DIP 19/07/20
130	HAAS 4 Axis - B4B	6 pcs	7/12/19	7/12/19	1.00	10.42	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	6 pcs	7/12/19	7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DTP 19-07-23
				QC 2 - 69	
150	QC 8	6 pcs	7/12/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
160	Packaging 3-1 - Stock - B4B	6 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B

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				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	6 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	→ 02 Bin: ST 479A
				QC 21 - SA - 70	JUL 26 2019
				QC 21 - SA - 53	70
9-89					
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2521 blank file Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	42 sf (7 ea)	120-Waterjet - Omax - 1	S143330	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-Waterjet - Omax - 1	MUHMWB10	42	1,021	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 196290
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261	✓		G.P.	
B	0.90	0.96	0.932	✓		Ver.	
C	0.27	0.330	0.310	✓		D.G.	
D	0.470	0.530	0.500	✓		Ver.	
E	21.740	21.760	21.750	✓		TAPE	
F	0.72	0.780	0.750	✓		Ver.	
G	0.35	0.410	0.380	✓		Ver.	
H	11.490	11.570	11.500	✓		TAPE	
I	3.41	3.47	3.44	✓		Ver.	
J	11.790	11.810	11.800	✓		TAPE	
K	9.47	9.53	9.500	✓		TAPE	
L	7.190	7.210	7.200	✓		Ver.	
M	6.910	6.970	6.940	✓		Ver.	
N	44.47	44.530	44.500	✓		TAPE	
O	6.590	6.650	6.620	✓		Ver.	
P	0.940	0.980	0.970	✓		Ver.	
Q	18.97	19.03	19.00	✓		TAPE	
R	0.350	0.410	0.380	✓		Ver.	
S	0.740	0.780	0.765	✓		Ver.	
T	0.240	0.280	0.265	✓		Ver.	
U	0.370	0.410	0.390	✓		Ver.	
V	0.740	0.780	0.760	✓		Ver.	
W	0.740	0.780	0.765	✓		Ver.	

Measured by: DAS 52 9-89	Audited by:	Prototype Approval: N/A
Date: 19/07/22	Date:	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

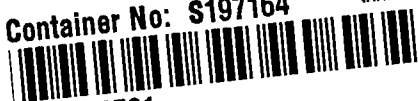
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S197164



Part: D2521

Job No: 196290

Serial No/Batch: S197164

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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